

Date: Monday, 04/05/2009 1:46:57 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GASKET
Job Number :	47711		
Estimate Number :	12722		
P.O. Number :		Part Number :	D353615
This Issue :	04/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3536 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	47315	Drawing Revision :	A
	Type :	Material :	
	SMALL /MED FAB	Due Date :	10/05/2009
Written By :		Qty:	10
Checked & Approved By :	<u>JD 09.05.09</u>	Um:	Each
Comment :	Est Rev:A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 1.1122 sf(s)/Unit Total : 11.1218 sf(s)
 NEOPRENE SHEET 0.063
 Batch: 111469 13 9-5-14

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3536
 Dwg Rev: A
 Prog Rev: A

13 9-5-14



2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

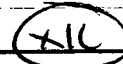
13 9-5-14

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

09/05/14



5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: Finishing

13

09-05-14



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 04/05/2009 1:46:57 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 47711

Part Number: D353615

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/15 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF

09-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47711
Description: Gasket		Part Number: D3536-15
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.18	U			
35.65	+/-0.030	35.65	✓			
33.65	+/-0.030	33.65	✓			
30.15	+/-0.030	30.15	✓			
24.90	+/-0.030	24.90	✓			
19.65	+/-0.030	19.65	✓			
14.40	+/-0.030	14.40	✓			
9.15	+/-0.030	9.15	✓			
5.65	+/-0.030	5.65	✓			
3.90	+/-0.030	3.906	✓			
8.00	+/-0.030	8.00	✓			
16.00	+/-0.030	16.00	✓			
24.00	+/-0.030	24.00	✓			
0.30	+/-0.030	0.309	✓			
0.30	+/-0.030	0.312	✓			
1.89	+/-0.030	1.886	✓			
Ø0.19	+0.005/-0.001	0.190	✓			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-5-14	Date: 09/05/14	Date:	N/A

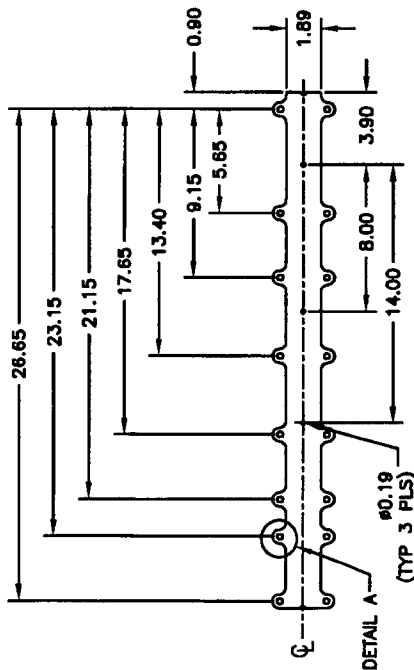
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

DART

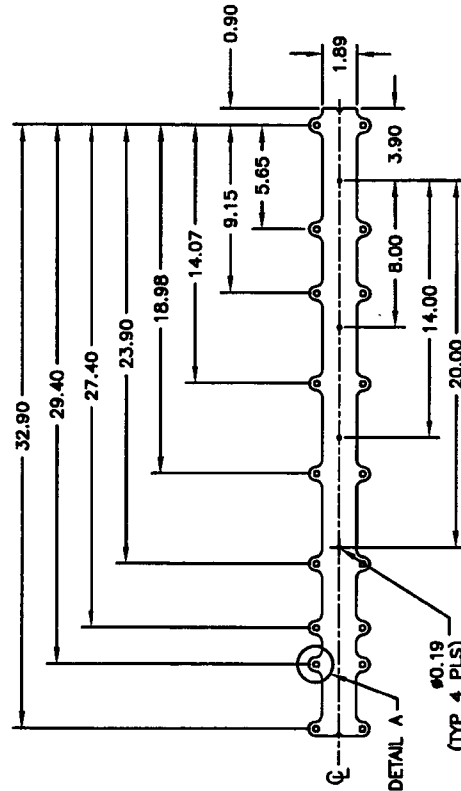
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CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3536	REV. A SHEET 1 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10
A	06.10.25	NEW ISSUE	

RELEASED

07.02.12 *[Signature]*



D3536-11 GASKET



D3536-13 GASKET

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WITHOUT NOTICE
WORK ORDER
NO. *4771*

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

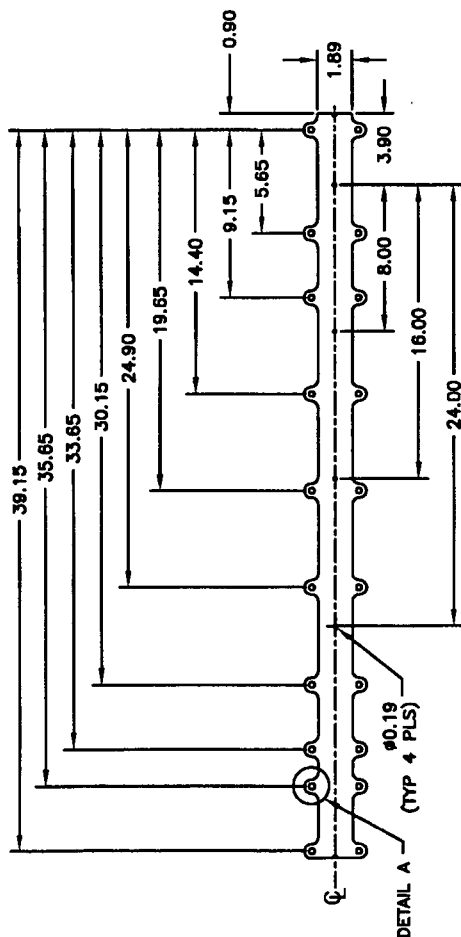
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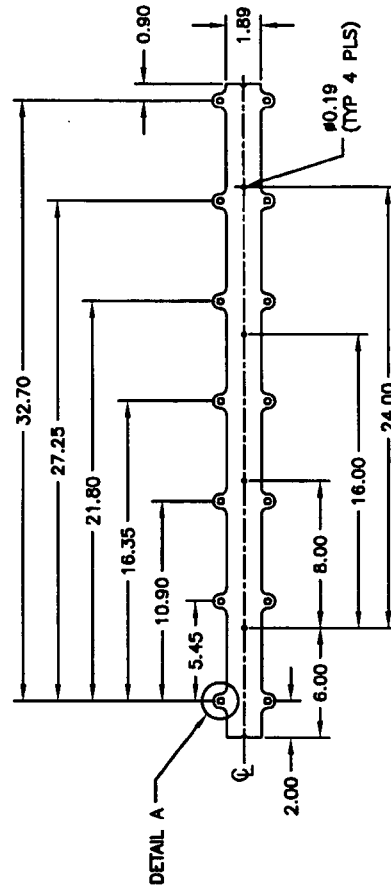
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DATE 06.10.25		TITLE GASKET	SCALE 1:10

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07.02.12



D3536-15 GASKET



D3536-21 GASKET


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REVISIONS
WORK ORDER
4274

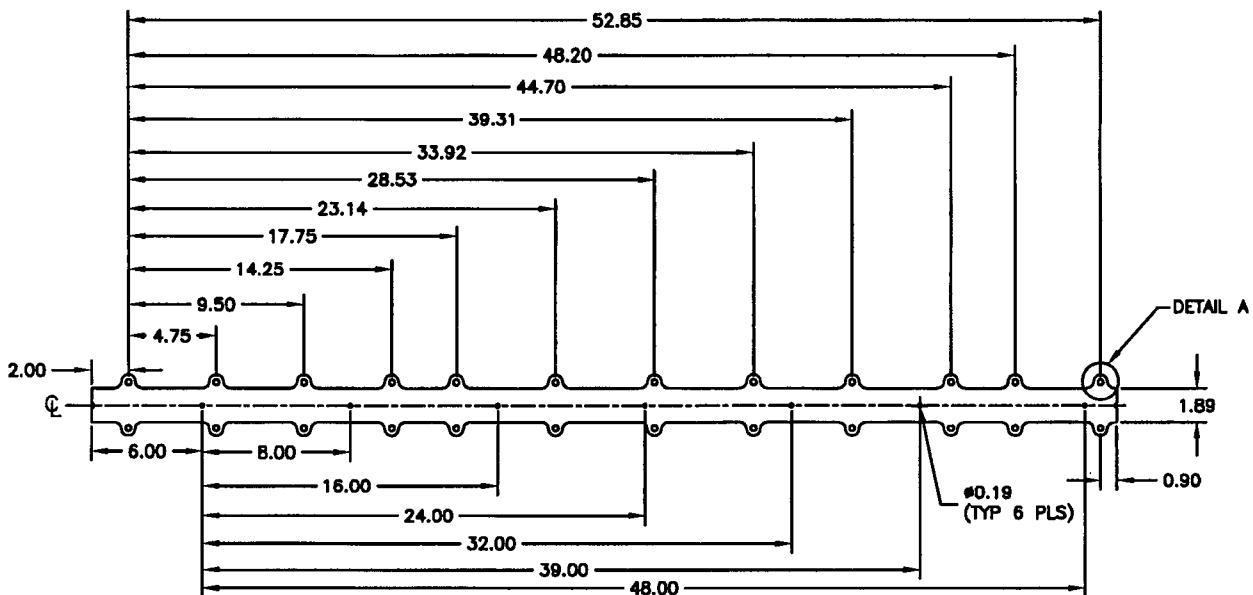
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 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

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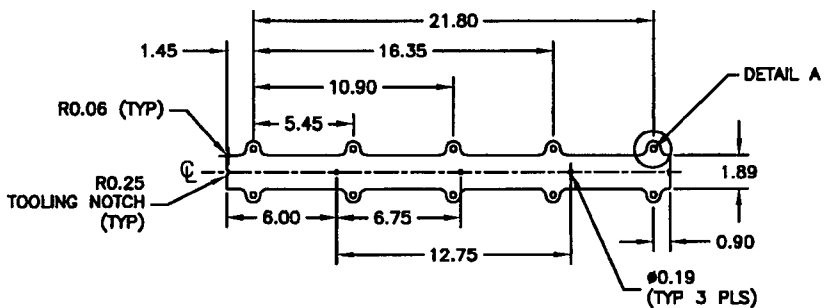
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CHECKED PH	APPROVED 	DRAWING NO. D3536	REV. A SHEET 3 OF 6
DATE 06.10.25	TITLE GASKET		SCALE 1:10



D3536-23 GASKET



D3536-25 GASKET

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NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

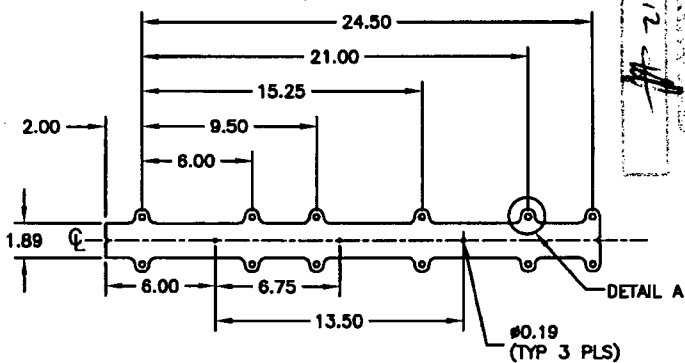
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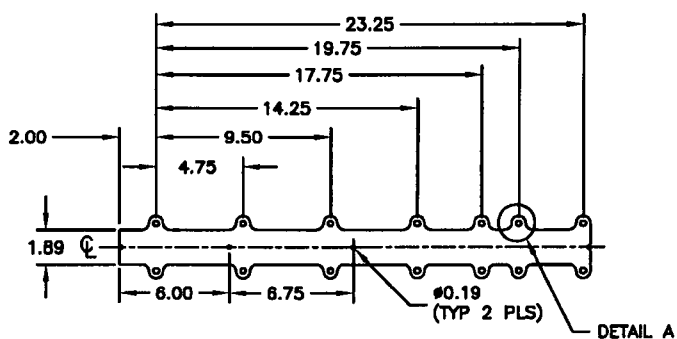
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DATE 06.10.25	TITLE GASKET	PORT HADLOCK, WA	
		SHEET 4 OF 6	SCALE 1:10

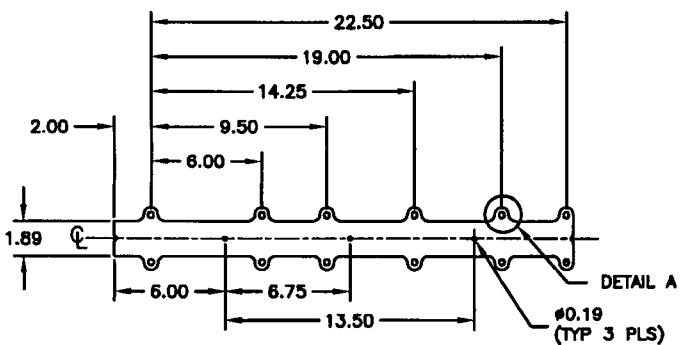
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

NOTES

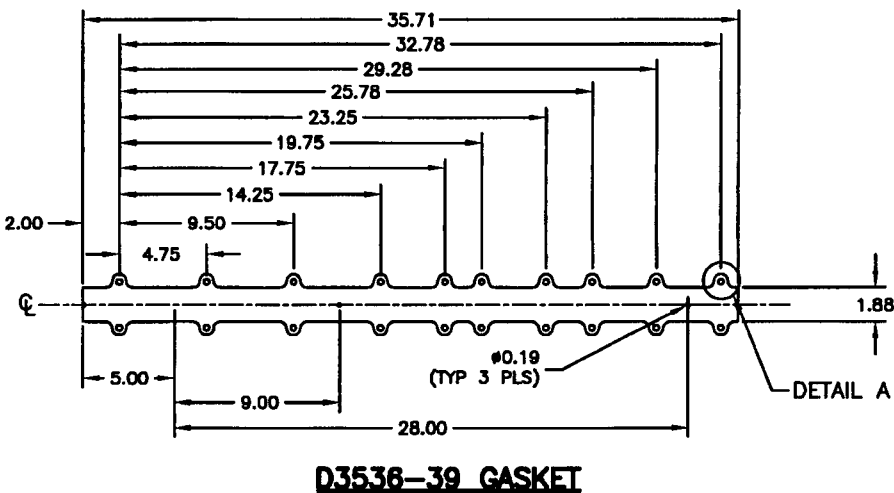
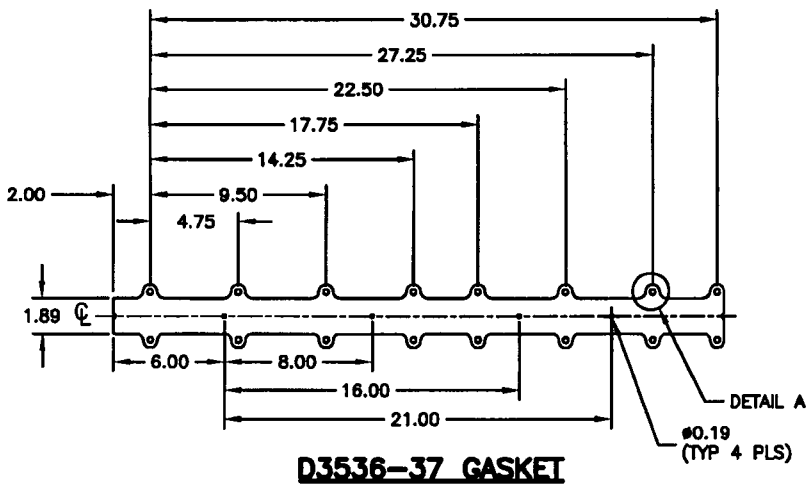
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 5 OF 6
		SCALE	1:10	

07.02.02 CH



NOTES

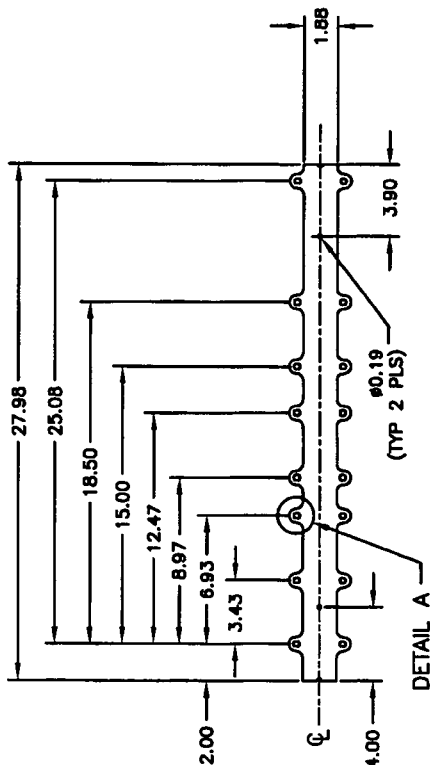
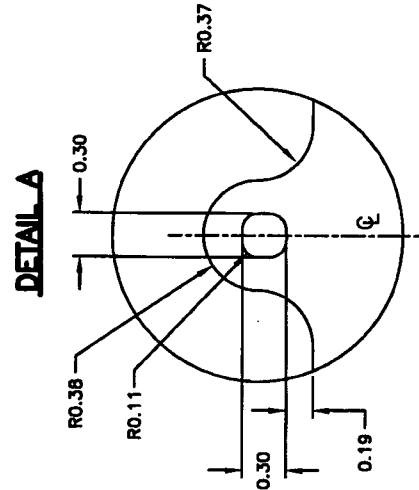
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- 2) FINISH: NONE
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D3536-41 GASKET

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
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